

Date: Monday, 7/30/2007 1:54:09 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 33798		
Estimate Number	: 12781		
P.O. Number	: N/A	Part Number	: D35641
This Issue	: 7/30/2007 S.O. No. : N/A	Drawing Number	: D3564 REVC
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C
Previous Run	: 33243	Material	: N/A
Written By	: <u>JA 07.07.30</u>	Due Date	: 8/30/2007
Checked & Approved By	: <u>JA 07.07.30</u>	Qty:	12 Um: Each
Comment	: Est Rev: A New Issue 07-03-08 ec Est Rev: B As per Rev C 07-07-09 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.9177 sf(s)/Unit Total: 11.0124 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: M105130

SAD 07/08/02

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\*

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

SAD 07/08/02

12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/02

12

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

EP 07/08/03

12

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT and DT

Form Joggles (2) as per Dwg D3564 on brake using Jig DT

07/08/07

FF. 07-08-08

FF 07-08-08

12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ED Date: 07/06/22  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/30/2007 1:54:10 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33798

Part Number: D35641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/08/07 (12) *ccenter*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

*M105138*

*FC 07/08/18 (12)*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/08/20 (12)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/08/20 (12)*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*m/04846*

*FL*

*07/08/21 (12)*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*m-h*

*07/08/21 (12x)*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*FP-14.*

*BL/m-h 07-08-21 (12)*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*FP 07/08/22 (12)*

Job Completion



*u 07/08/22*

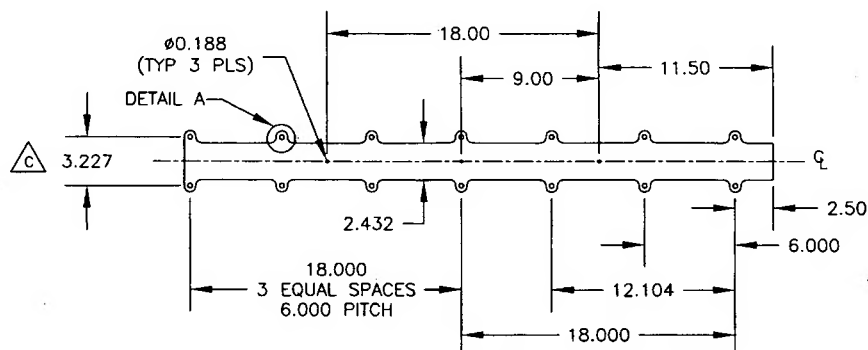
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

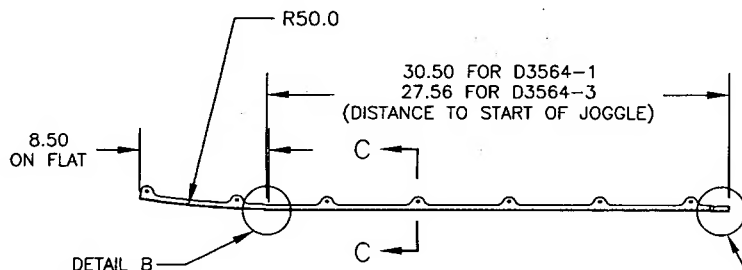
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

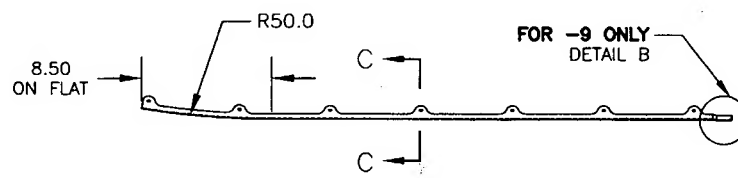
NOTE: Date & initial all entries



**D3564-1F FLAT PATTERN**

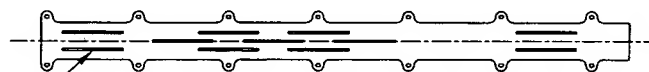


**D3564-1/-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-9/-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD  
4.0 LONG  
0.063 TO 0.125 HIGH  
(TYP. 11 PLS.)  
WELD AFTER BENDING AS  
ILLUSTRATED PER DT8308



**D3564-1/-3/-9/-11 WELDING DETAIL**

**RELEASED**  
07-06-28-17

**D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES**

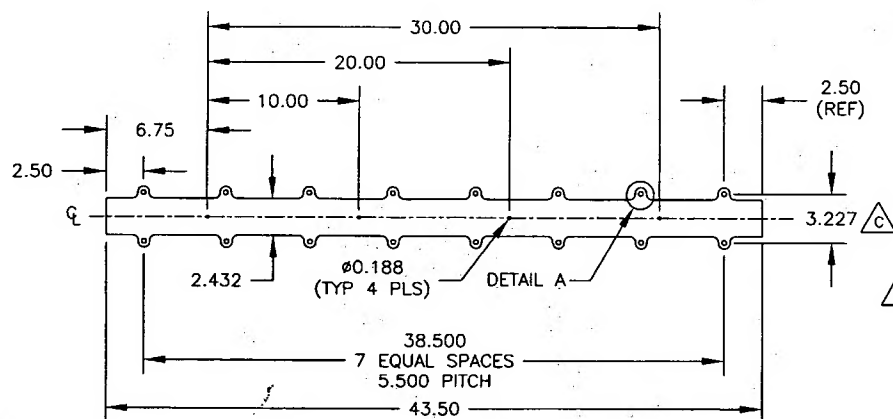
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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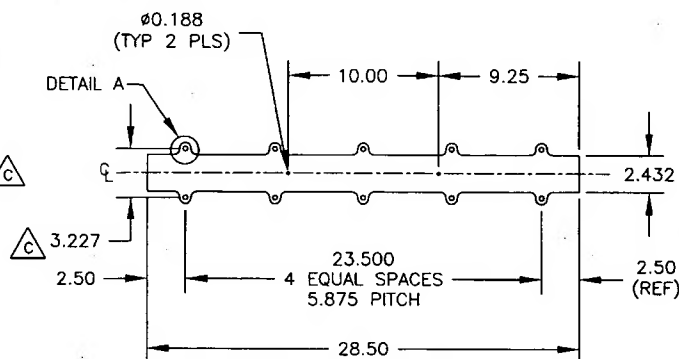
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE	07.04.17	TITLE WEARSHOE
		REV. C SHEET 1 OF 2 SCALE 1:8

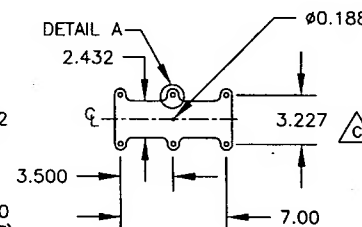
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WORK ORDER  
NO. 33798



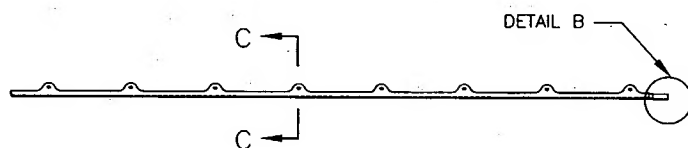
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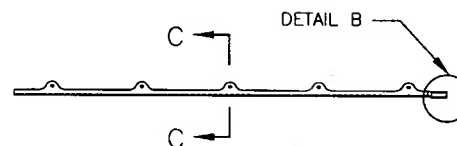
**D3564-7F FLAT PATTERN**



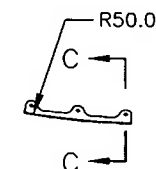
**D3564-13F FLAT PATTERN**



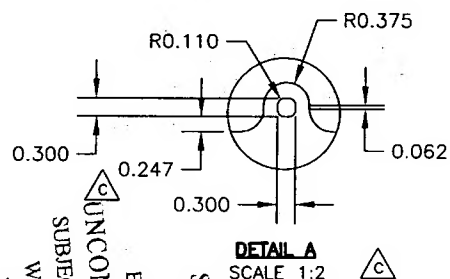
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



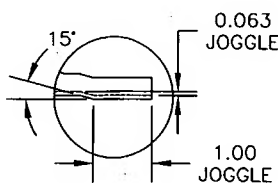
**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



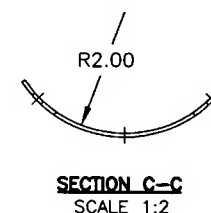
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



**DETAIL A**  
SCALE 1:2



**DETAIL B**  
SCALE 1:2



**SECTION C-C**  
SCALE 1:2

**RELEASED**  
07.04.17

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CHECKED	APPROVED	DRAWING NO. D3564	REV. C SHEET 2 OF 2
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:8

